

Work Order ID 119678

119678

Page 1

May-15-14 3:38:29 PM

Item ID: D3525-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Placard

Start Date: 5/15/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-05-23

Tooling: _____ Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3525	Rev A								

100

100

PURCHASING

Purchasing

Memo

0.00

CD 14/05/26 20

Purchasing

Issue P/O: 24349 Make per Dwg D3525 Manufacture from 3M
7mil masking film p/n 8522CP or Avery IPM #2031Material release note
required

110

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

20x Sp/14-5-30

Packaging

Memo

0.00

Ensure material release note is attached

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

DAS

27

9:39

115/30

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General					
	<input type="checkbox"/>	Bending	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions
	<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance
	<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect
	<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing
	<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved
	<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong
	<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge
	<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Pressure/Forced
	<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Off-set	<input type="checkbox"/>	Set-up
	<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>	Temperature/Cure
	<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>	Weld
						Wrong Stock Pulled
						Other

Work Order ID 119678

119678

Page 2

May-15-14 3:38:29 PM

Item ID: D3525-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Placard

Stop

NS2

Start Date: 5/15/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: STOPL

0.00

DAS
26
9-89

130

Packaging

Packaging

Memo

0.00

201 14-06-02

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MLJ 14-06-02

MLJ

14-06-02

DQA: _____ Date: _____

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only



Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
									<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		
									<input type="checkbox"/> Other		

Picklist Print

Page 1

May-15-14 3:38:32 PM

Work Order ID: 119678

119678

Parent Item: D3525-1

D3525-1

Parent Item Name: Placard

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B 06.08.23 New issue EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3525-1P	Purchased	No		100	Each	0.0000	1	20	**	20	14-5-30	Sof
----------	-----------	----	--	-----	------	--------	---	----	----	----	---------	-----

D3525-1P

Placard

DQA: _____ Date: _____

Date:



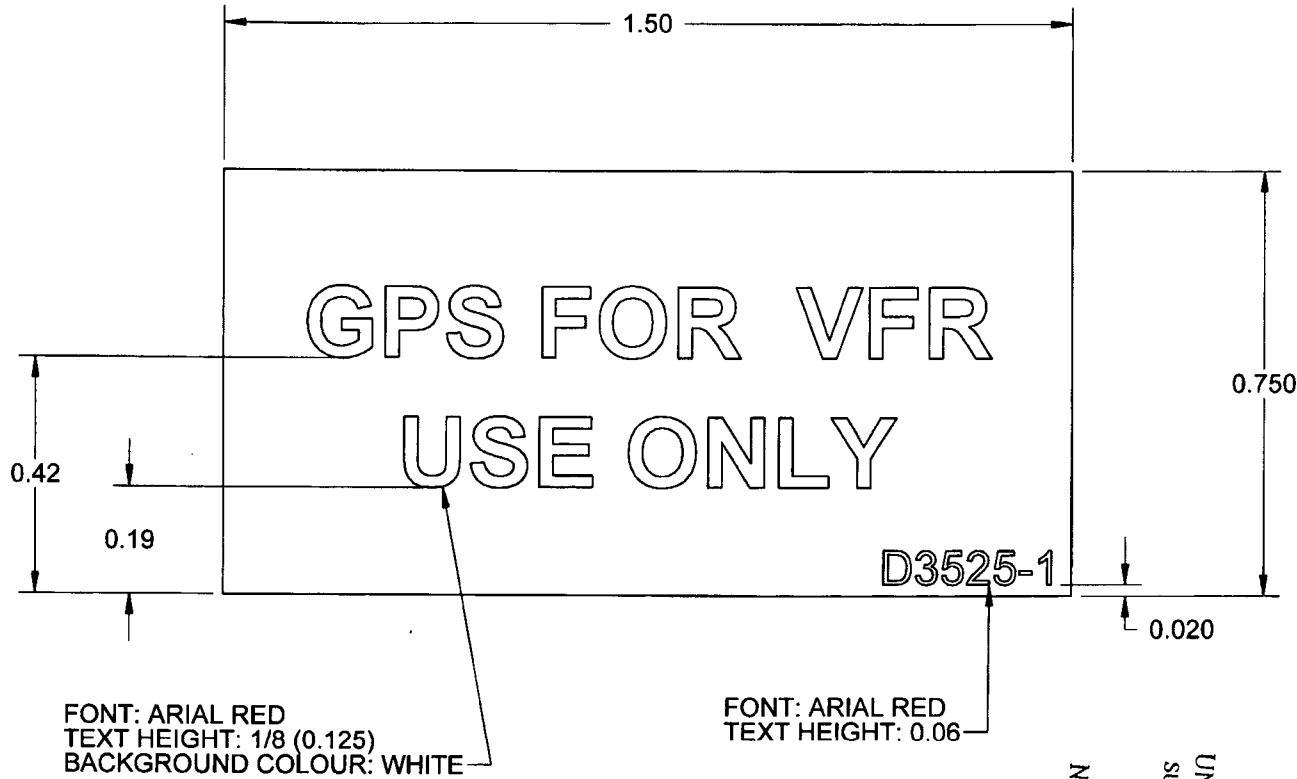
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

DART

DESIGN <i>CB</i>	DRAWN-BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3525	REV. A	SHEET 1 OF 1
DATE 06.09.19		TITLE PLACARD	SCALE 3:1	
REV A	DATE 06.09.19	DESCRIPTION NEW ISSUE		

RELEASED
07.08.03

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *119678*
14-03-23

NOTES:

- 1) RED LETTERS ON WHITE ADHESIVE BACK VINYL
- 2) MANUFACTURED FROM: 3M 7mm MASKING FILM #8522CP OR
AVERY IPM #2031, 1.5 LONG x 0.75 WIDE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24349**

Purchase Order Date 5/26/2014
PO Print Date 5/26/2014

Page Number 1 of 2

Order From : VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name
Vendor Phone 613 632 5449

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Pri
	Line Comments		Promise Date				
	Delivery Comments						
1	D3428-1P	Placard	5/30/2014 Yes 5/30/2014	20.00 Each		\$4.00	\$80.0
	AS PER DWG D3428 REV. A B119695						
						Line Total:	\$80.0
2	D3525-1P	Placard	5/30/2014 Yes 5/30/2014	20.00 Each		\$4.00	\$80.0
	AS PER DWG D3525 REV. A B119678						
						Line Total:	\$80.0
3	D5055-3P	Placard	5/30/2014 FN Yes 5/30/2014	12.00 Each		\$6.67	\$80.0
	AS PER DWG D5055 REV. A B119593						

Note:

SP/4-5-30

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 22283
Date: 05/29/2014
Ship Date: 05/28/2014
Page: 1
Re: Order No. WO12636

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

632-9577

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
			PO# 24349 20 D3428-1P 20 D3525-1P 12 D5055-3P Chantal Lavoie	H	4.0000	80.00
			Subtotal:	H	4.0000	80.00
			H - HST 13% HST	H	6.6667	80.00
						240.00
						31.20
Studio de Lettrage HST: #825007651RT0001						
Shipped By:	Tracking Number:					
Comment:	Avery Hi Tack MPI 2006				Total Amount	271.20
Sold By:						

****Certificate of Conformity****

Customer:

Studio de Lettrage

Purchase Order #:

PO #24349

Packing Slip #:

WO 12636

Part #:

Serial #:

Description:

D3428-1P, D3525-1P, D5055-3P

Quantity:

52 all together

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery

APPROVAL: Natasha B-Lafleche

Signature: 

DATE:

May 29 2014

Title: Production Coordinator

PRODUCT DATA SHEET



Avery® IPM™ 2031

issued: 01/04/2005

Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.
Adhesive: removable, acrylic based
Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminate and Avery® Digital Print Media

Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility.

Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorsprint. The warranted period varies from type of application and type of overlaminates from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

Page 1 of 2

PRODUCT CHARACTERISTICS

Avery® IPM™ 2031

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	80 µm
Gloss	ISO 2813, 20°	1%
Dimensional stability	DIN 30646	0.3 mm. max
Adhesion, initial	FINAT FTM-1, stainless steel	180 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	260 N/m
Flammability		Self extinguishing
Accelerating ageing	DIN 53587, 500h exposure	No negative impact on film
Shelf life	Stored at 22° C/50-55 % RH	Performance
Removability		2 years
Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC		
Durability ²	Overlaminated with DOL 4300 Overlaminated with DOL 1000, DOL 1100 with overlaps Overlaminated without overlaps for static applications only Without overlaminates and used for static, Non-abrasive application ONLY	5 years 3 years 2 years 18 months

Only when printed with ENCAD GO, HP and Colorscape pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

Temperature range

Features	Results
Application temperature	Minimum: +10°C
Service temperature	-20°C to +80°C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.

